permeability of 2400 l/10cm²*h, and preferably more than 4500 l/10cm²*h.

4. The weight of the separation cloth is preferably between 600 g/m² and 2000 g/m² Fabrics with less weight usually wear out too fast, where too heavy fabrics tend to elongate too much under its own weight, so causing obstruction in the furnace for the glasses to pass in the neighbourhood of the fabric before or after the bending action.
5. The thickness for the separation cloth is preferably more than 0.8 mm and even better more than 1mm. Too thin fabrics show a lack of elasticity in the direction perpendicular to the fabric surface.
6. And as already mentioned, the risk for remaining marks on the glass surface should be reduced to a minimum.

The higher the number of requirements met, the better the performance of the separation cloth between mould and glass in the glass bending process will be.

Summary of the invention.

It is an object of the present invention to provide a fabric with a reduced risk for markings on the glass surface.
It is also an object of the present invention to provide a fabric which meets all of the above-mentioned minimum requirements.

The invention relates to a knitted fabric, which comprises fibres, at least part of these fibres being metal fibres, and which has more than 90 stitches per square centimetre.

Preferably the knitted fabric has more than 95, most preferably more than 100, e.g. more than 105 or even more than 110 stitches per square centimetre.

The first requirement, being the resistance to the temperatures used for the bending of the glass, is met by the use of metal fibres, usually stainless steel fibres.

Possibly, other high temperature fibres, such as glass fibres, ceramic fibres, TWARON®, NOMEX®, meta-aramid fibres, para-aramid fibres, carbon fibres, preox-fibres and other high temperature resistant man-made fibres can be used, next to the metal fibres. The fibres, of which at least one are metal fibres, can be intimately blended and possibly plied to a two or more plied yarn or the yarn can be a two- or more plied yarn, where some or all of the single yarns are made out of one fibre type.

By plying yarns, it is meant that two or more yarns are given a torsion round the direction of the axis's of the yarns.

To meet the second requirement, being the drapeability, usually knitted structures are used.

The other characteristics, air permeability, thickness, weight and number of stitches, are largely influenced by the gauge of the knitting machine, the metrical number of the used yarns, the knitting structure and the settings of the knitting machine during the knitting action. The higher the number of stitches per square centimetre, the heavier and thicker the fabric and the lower the air permeability. The inventors, however, have discovered that the risk for glass markings can be substantially reduced, if not avoided, if the fabric has a higher number of stitches per surface unit and that this higher number of stitches can be reached with values of air permeability, thickness and weight which still fall within the above-mentioned ranges.

The reduced risk for markings on the glass surface can be explained as follows :

To reduce the risk on creating marks on the bent glass surface, it is important to use a fabric with as much yarn surface as possible on the fabric side which contacts the glass during the bending operation. This for 2 reasons:

1. By having more yarn surface on this contact side, the force to bend the glass is distributed over more contact surface. The depth to which extend the fabric might be pressed into the softened glass largely depends on this force per surface, so less force per unit decreases the risk on having a too large impression of the fabric in the glass, and so creating marks on the glass surface.
2. Because this less force per contact surface unit, the wear due to the repetitive mechanical action on the fabric surface will be reduced. This makes the time to have too much yarn pronunciation longer and the risk to have marks will be decreased in time.

The yarns which can be used to realise fabrics, as subject of the invention are made out of metal fibres, usually stainless steel fibres, possibly blended with glass fibres or ceramic fibres, other high temperature fibres, such as TWARON®, NOMEX®, meta-aramid fibres, para-aramid fibres, carbon fibres, preox-fibres and other high temperature resistant man-made fibres. The fibres, of which at least a part being metal fibres, can be intimately blended and possibly plied to a two or more plied yarn or the yarn can be a two- or more plied yarn, where some or all of the single yarns are made out of one fibre type.

At least partially, the yarns will contain metal fibres. Usually, but not necessarily, stainless steel fibres are used. Alloys such as AISI 316 or AISI 316L, AISI 347, or other alloys out of the AISI 300 type are used. Also alloys out of the AISI-400 type or Aluchrome-type alloys can be used. These fibres can be bundle drawn, as described in patent US-A-3379000, be made by shaving them from a coil, as described in patent